

# Work Order ID 65005

Wednesday, January 05, 2011 1:26:10 PM



Page 1

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 1/5/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-01-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3622

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622 ,

FOLIO REV: *B*

DWG REV: *SA*

2-DEBURR AS REQUIRED

*11/1/24*

*20* *φ*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*SA 11/1/24*

*20* *φ*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*SA 11/1/25*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65005**

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Item ID: D3622-1

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Setup Start



Revision ID:

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Item Name: Ball Stud

Start Date: 1/5/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 70

0.00



Packaging

Memo

0.00

Packaging

11/1/26 SP (20)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/27 JJ  
CL 11/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 05, 2011 1:26:14 PM

Page 1

Work Order ID: 65005

Parent Item: D3622-1

Parent Item Name: Ball Stud



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303H0.500

Purchased

No

100

f

104.7480

0.108

2.273684



303 HEX BAR .500



2.3 11/1/24

Location

Loc Qty

Loc Code

MAT037

104.748

109778

99.548

109846

5.2

2.3

~~2.3~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

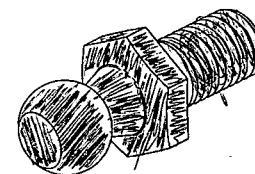
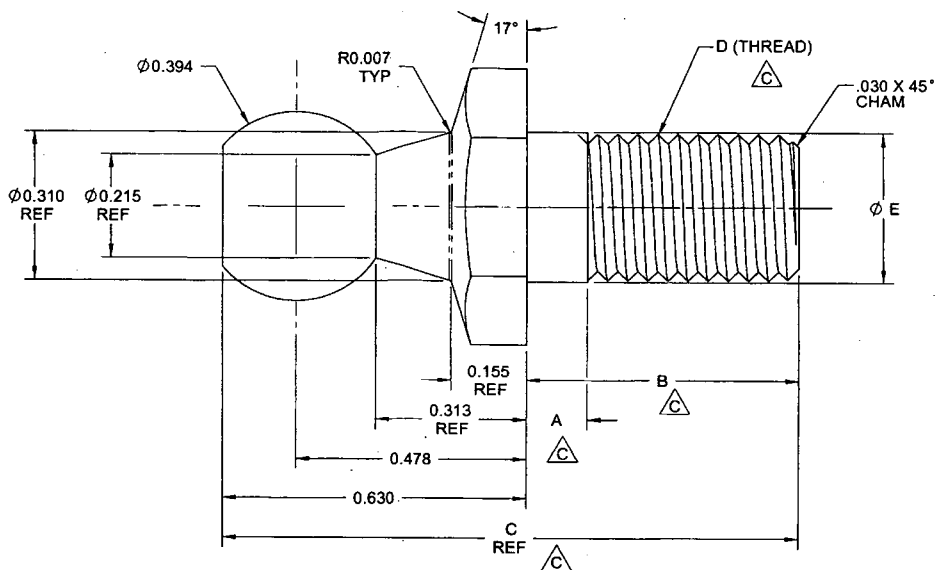
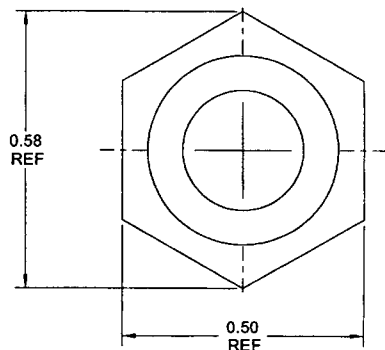
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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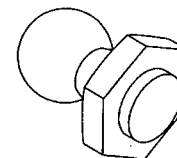
**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D3622-1 BALL STUD SHOWN**



**D3622-11 BALL STUD SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN	Ø E MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

**D3622-X BALL STUD**

- NOTES:
- 1) MATERIAL: AISI 303 HEX BAR  
REF DART SPEC M303H0.500
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
  - 7) WEIGHT: SEE D3622-X TABLE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 15905

11-01-5

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D3622	
CHECKED	JPH	REV. C	
MFG. APPR.	JPH	SHEET 1 OF 1	
APPROVED	JPH	TITLE BALL STUD	
DE APPR.	JPH	SCALE NTS	
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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